

5/20

127mm

DART AEROSPACE LTD	Work Order:	23045
Description: Short in Bracket	Part Number:	D3330-13 11
Dwg: D3330 Rev. A PAGE 9 RF 05.01.17	Qty:	14 20 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	DK	05.04.15	20
2	MV	Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-13 11	SD	05.05.04	15
3	MV	Machine as per Folio FA480 and Dwg D3330 Identify as D3330-13 11	SD	05.05.04	15
4	QC2	Inspect parts as they come off the CNC machine	SD	05.05.04	15
5	QC8	Second check	SD	05.05.04	15
6	MV	Deburr	SD	05.05.04	15
7	QC5	Inspect work to Step 6	SD	05.05.05	14
8	ST	Identify and Stock	OPC	05.05.05	14
9	AC	Cost / part: 22.33	SD	05.05.06	14
10	DC	Close W/O 19.60 Inspect Level 21	DK	05.05.11	14

N
Mat.

PT.6

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	DK

RELEASED
05.01.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-05	3	bottom hole drilled And bored on the wrong side.	<i>MP</i>	Scrap & destroy. No mat'l to replace. See NCR 874	2 05-05-05	2 05-05-05	<i>MP</i> 05/05/05	2 05-05-05

Part No: 3330-11

PAR #: _____

Fault Category: _____

NCR: Yes

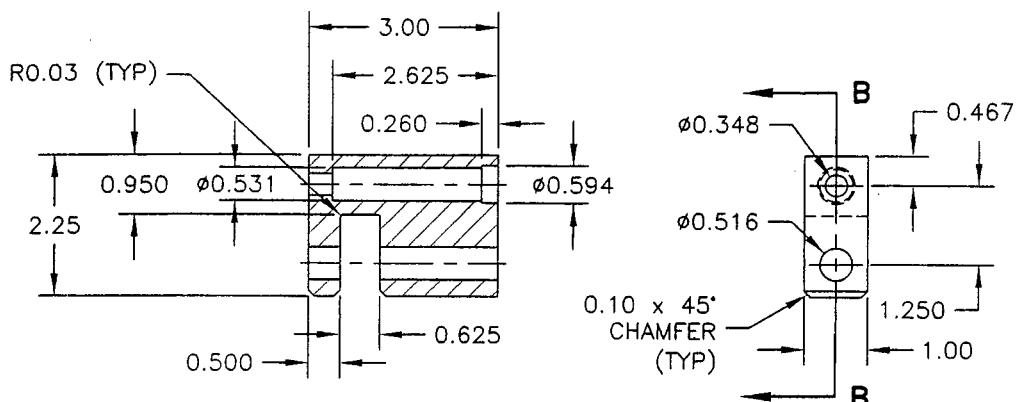
No

DQA: DPDate: 05-05-11

NOTE: Date & initial all entries

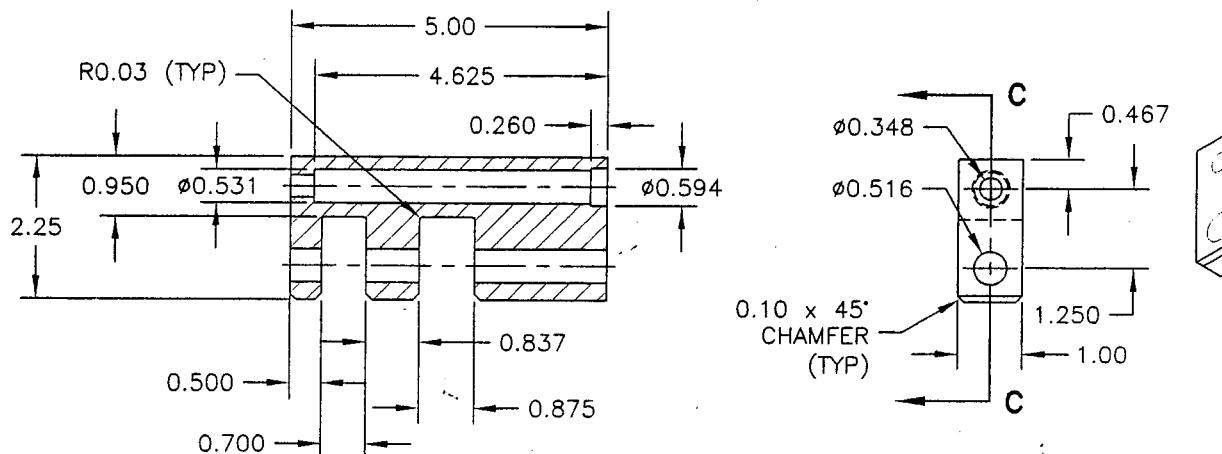
QA: N/C Closed: _____

Date: _____



SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET

SHOE/COPY

RETURN TO
LIBRARY

UNIVERSITY OF TORONTO LIBRARY COPY

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

WORK ORDER
NO. 23045

NO. 23045

Job Costing Report

Dart Aerospace Ltd.
HawkesburyApr 12, 2005
02:25 pm

Work Order No : 0023045
 Project Name : D3330-13
 Project For : WK520
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3330-13
 Description : Short Pin Bracket
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 04-12-05
 Est Finish Date : 05-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

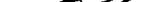
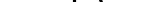
	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	23045
Description:	Part Number:	D3330-11
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	S.D	Audited by:		Prototype Approval:	
Date:	05.05.04	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	